

Date: Tuesday, 02/06/2009 11:30:31 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 350 BASKET BASE (SHORT)
<b>Job Number</b> : 48311A	
<b>Estimate Number</b> : 10209	
<b>P.O. Number</b> :	<b>Part Number</b> : D3265041
<b>This Issue</b> : 02/06/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3265 REVC
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : // <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 48310A	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 10/06/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.06.02</u>	
<b>Comment</b> : Est Rev:C Re-Format 05-11-03 JLM Est Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified by:EC Est rev E 09.03.23 updated per B46309A EC verified by:DD	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
<b>Comment:</b> Qty.: 19.2150 f(s)/Unit Total : 19.2150 f(s) 3/4" x 3/4" x 0.065" wall 304/316 SS tubing. (M304TS0.750W.065) Batch: <u>M111885</u>		
2.0	D3826041	Rib / Gusset Assembly
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib / Gusset Assembly <u>B47571</u>		
3.0	D22323	Basket Hinge
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2232-3 Hinge bracket <u>B416949</u>		
4.0	D22351	Basket Rib
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Basket Rib <u>B418319</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 02/06/2009 11:30:31 AM  
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Drawing Name: 350 BASKET BASE (SHORT)

Job Number: 48311A

Part Number: D3265041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-3

Bushing

B44274

PD 09-06-17

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B47264

PD 09-06-17

7.0

D34425

Shim



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3442-5

Shim

B32282

PD 09-06-17

✓ 8.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 26.0000 sf(s)/Unit Total : 26.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

26sf M304EX0.75-16F

Expanded Metal

M111956

SAD 09-06-16

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-CUT (3) D2235-1 FROM D3166-1

2-Drill hole in D3265-3 as per Dwg D3265

3-Remove all markings from material

4-Weld as per Dwg D3265 using Welding Table and corner JigDeburr as required

PD 09-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: 350 BASKET BASE (SHORT)

Job Number: 48311A

Part Number: D3265041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*09-06-17*

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*09/06/17*

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*pressure wash 09-06-17 v1A1*

1ST COAT:

START TIME:

*1:50pm*

OVEN TEMPERATURE:

*400°F*

FINISH TIME:

*2:20pm*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*/*

*09-06-17*

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*09-06-18*

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Small Medium Fab

Seal support gusset seam with White Sikaflex-291

Batch: *MN1567*

Expiry date: *10/01*

*09-06-18*

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*09/06/17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Part Number: D3265041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

RP43

9/6/19

SD

17.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf  
09-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
2	D2232-3	HINGE PLATE
4	D2235-1	RIB
4	D2325	SUPPORT GUSSET
2	D2327-3	BUSHING
2	D2581	MOUNTING BRACKET
2	D3265-1	RIB
2	D3265-3	RIB
2	D3265-5	RIB
2	D3442-5	SHIM

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1183115

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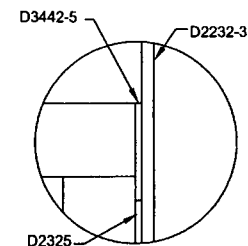
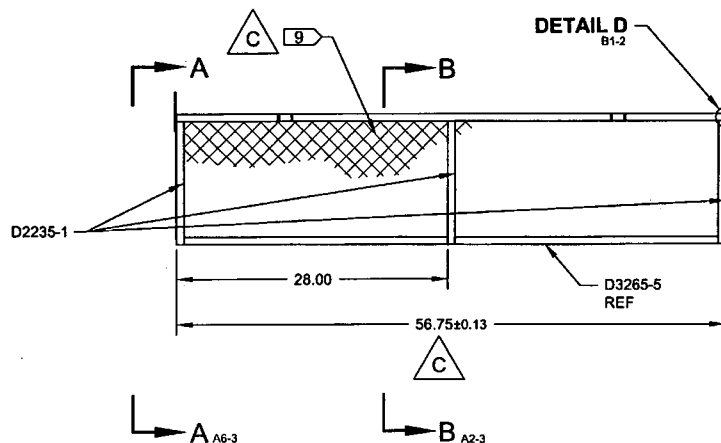
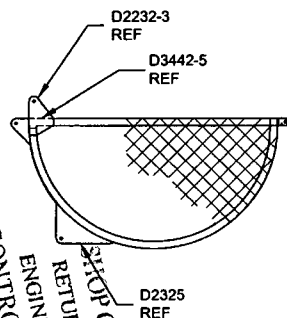
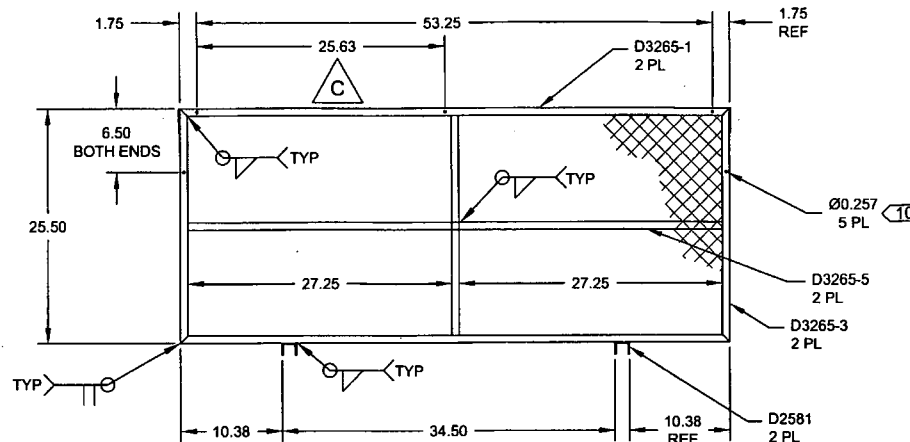
RELEASED  
08-09-01/11P



**NOTES:**

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. SHT 4 ADDED. RIB MATERIAL WAS 0.060 THICK. SHT 2 ZONE D5 25.63 DIMENSION WAS 27.63.	AJS	08.08.14
B	INCORPORATED A1. ADD SHIM UNDER HINGES. ADD HOLES FOR SPLIT LID BASKETS.	PH	05.06.08
A	NEW ISSUE	CP	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3265	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.08.14	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**DETAIL D** C4-2  
(BOTH ENDS)  
SCALE 10X

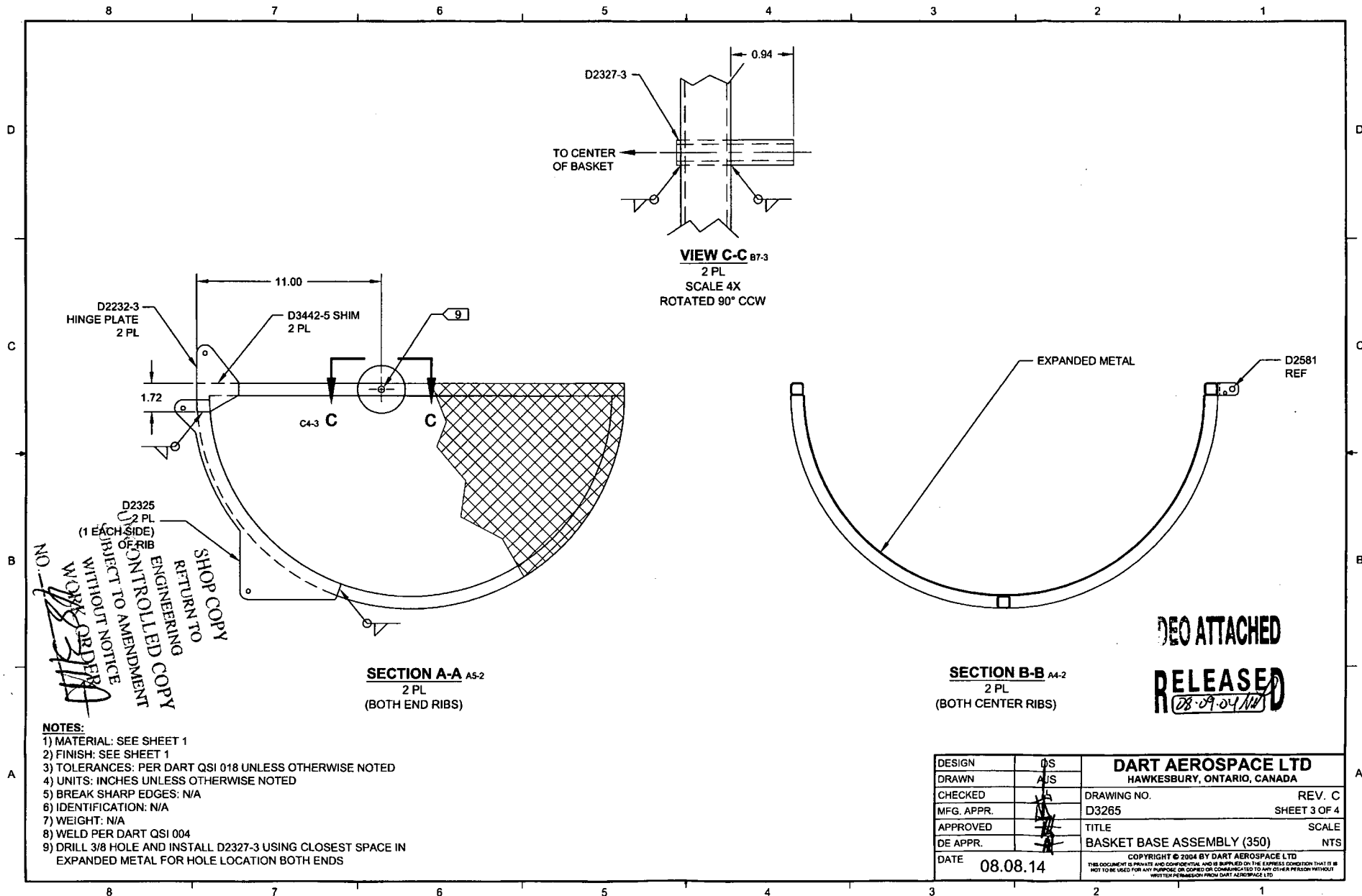
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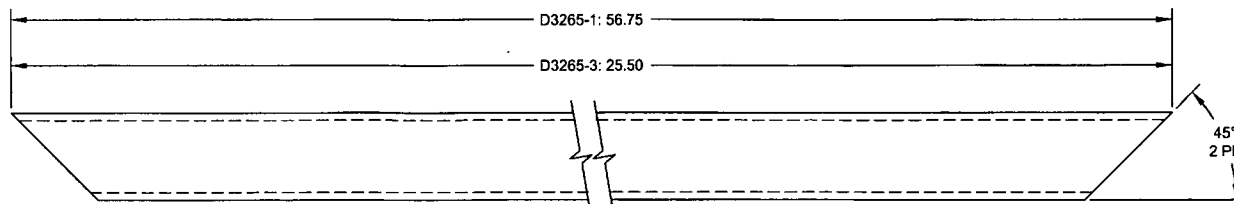
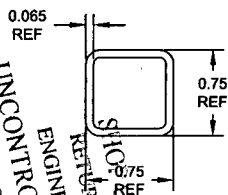
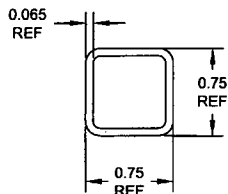
**BASE ASSEMBLY NOTES:**

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) SKIN INSIDE SURFACE OF BASKET WITH EXPANDED STEEL MESH. TACK WELD EACH END OF STRAND TO FRAME.
- 10) DRILL WHEN ASSEMBLING WITH D3267-041/-043 LID ONLY.

**D3265-041 BASKET BASE ASSEMBLY**

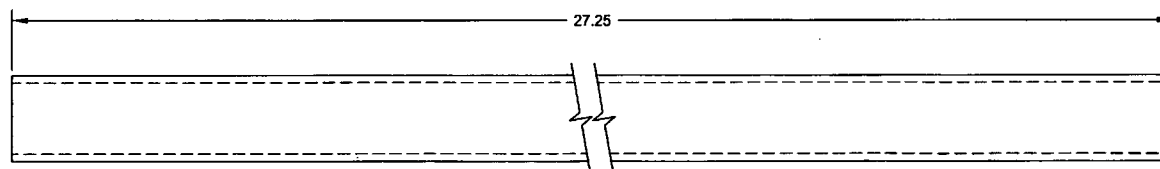
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RE</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>ESD</i>	D3265	SHEET 2 OF 4
APPROVED	<i>MS</i>	TITLE	SCALE
DE APPR.	<i>MS</i>	BASKET BASE ASSEMBLY (350)	NTS
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**D3265-1 RIB**

**D3265-3 RIB**



**D3265-5 RIB**

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ENGINEERING  
RETURN TO  
SHOOT COPY

- NOTES:**
- 1) FRAME MATERIAL: SEE SHEET 1
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>Red</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>Red</i>	D3265	SHEET 4 OF 4
APPROVED	<i>Red</i>	TITLE	SCALE
DE APPR.	<i>Red</i>	BASKET BASE ASSEMBLY (350) NTS	
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DRAWING NO. D3265	TITLE BASKET BASE ASSEMBLY (350)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3265-C-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN <i>[Signature]</i>	CHECKED <i>PH</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.04.16	DATE 09.04.16	DATE 09.04.16	DATE 09.04.16		DATE 09.04.16		

SHEET 1, MODIFY PARTS LIST AS FOLLOWS:

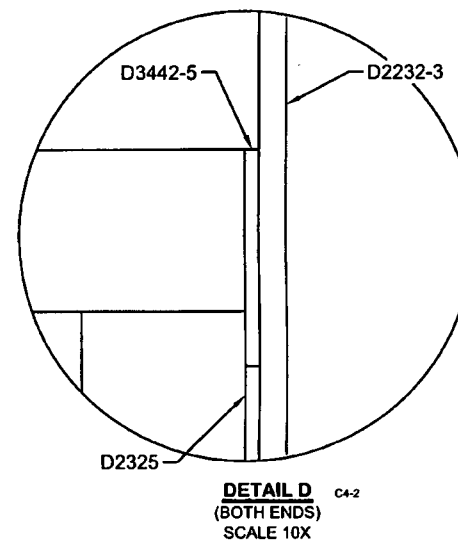
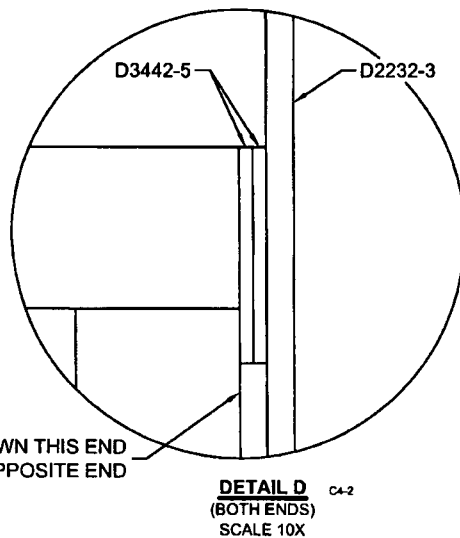
IS:

QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
3	D2235-1	RIB
2	D3929-041	GUSSET ASSEMBLY
2	D3929-042	GUSSET ASSEMBLY
4	D3442-5	SHIM

WAS:

QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
4	D2235-1	RIB
4	D2325	SUPPORT GUSSET
2	D3442-5	SHIM

SHEET 2, MODIFY DETAIL D AS SHOWN:



**RELEASED**  
01/04/22

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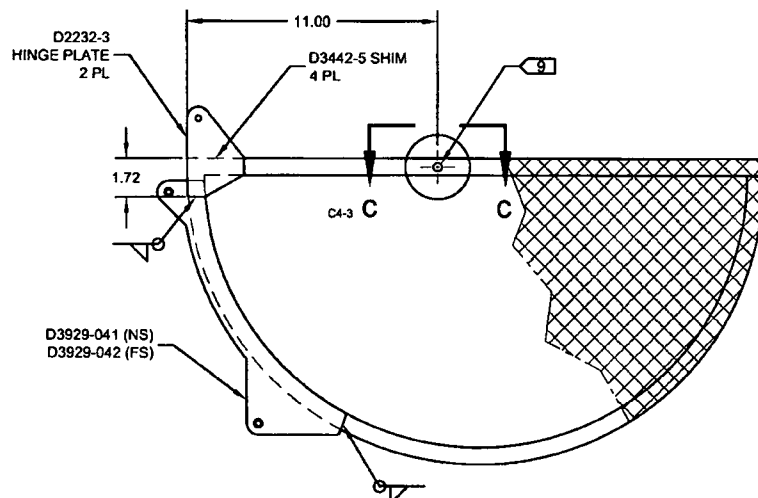
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DRAWING NO. D3265	TITLE BASKET BASE ASSEMBLY (350)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3265-C-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN B	CHECKED PH	MFG. APPR. AB	APPROVED H	DE APPR. H		
DATE 09.04.16	DATE 09.04.16	DATE 09/04/17	DATE 09.04.17	DATE 09.04.17		

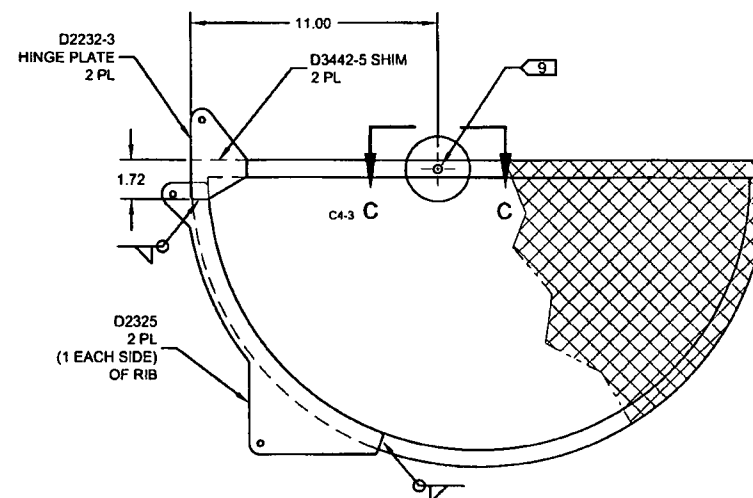
SHEET 3, MODIFY SECTION A-A AS SHOWN:

IS:



**SECTION A-A** AS-2  
2 PL  
(BOTH END RIBS)

WAS:



**SECTION A-A** AS-2  
2 PL  
(BOTH END RIBS)

RELEASED  
09/04/2017

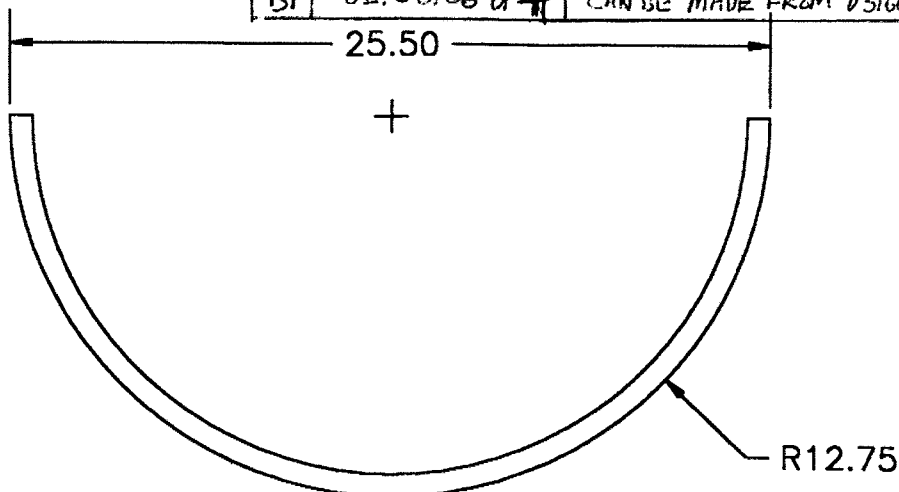
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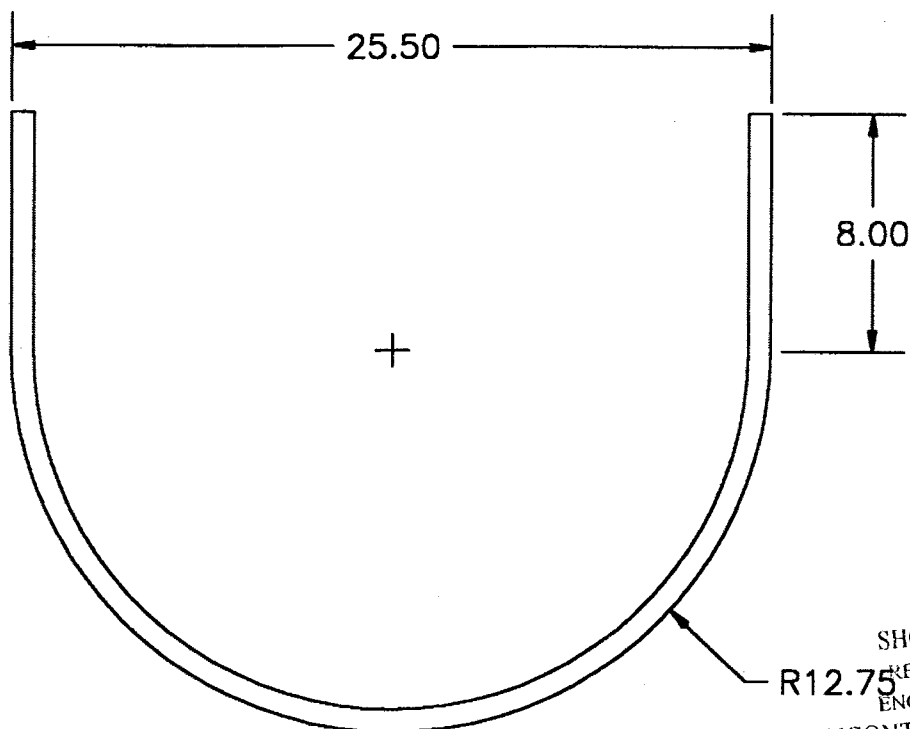
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B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>BW</i>	<i>BW</i>	D2235	SHEET 1 OF 1
DATE	TITLE		SCALE
94:12:16	BASKET RIBS		

BI	02.08.06 <i>U#</i>	CAN BE MADE FROM D3166-1
----	--------------------	--------------------------

RELEASED  
R 960507



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 *BI*  
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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